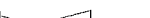




- NOTES
- A.C.N. 010 600 987
- 1: ALL WELDING TO BE TIG PROCESS USING 4043 FILLER WIRE. WELD DISTANCES IN INCHES.
 - 2: PRIOR TO WELDING REMOVE OXIDE COAT WITH STAINLESS STEEL WIRE BRUSH.
 - 3: CHROMATE INSIDE OF TUBES BEFORE SEALING.
 - 4: COMMERCIAL MATERIALS MUST BE SUPPLIED UNDER COVER OF N.A.T.A. CERTIFICATE FOR CHEMICAL PROPERTIES AND HARDNESS TO A5173-1986 FOR SHEET AND PLATE AND TO A51866-1986 FOR EXTRUSIONS.
 - 5: VISUALLY CHECK FOR CORROSION PITTING, STRAIGHTNESS AND FREEDOM FROM KINKS, DENTS AND HEAVY SCRATCHING.

[illegible]

REFERENCE DRAWINGS		MANUFACTURING OPERATIONS		MATERIAL	DIMENSIONS IN INCHES (MM)	<div>Helitech PTY LTD</div> <div></div> <div>BRISBANE HEADQUARTERS 141 MARLBOROUGH AVE., EAGLESHAM Incorporated In Queensland <div>C Helitech Pty Ltd (1998).</div><div>This drawing and designs contained herein remain the property of HELITECH PTY. LTD. (they may not be copied or reproduced without written permission from the above.</div></div> <div>PHONE: (07) 32684077 FAX: (07) 32687915 AS 1100</div>		DRAWN NORA KINNEUNEN	DATE 15/04/98	SCALE 1:2	CHECKED BY C.W. WHITNEY	DATE PLOTTED 15/04/98	Client HELITECH PTY. LTD.		Title KWIK FLOAT INSTALLATION CENTRE BOTTLE RACK MANUFACTURE DETAILS BELL 206 A & B SERIES		ERN 330	CI 117	Drawing Number BHA/DRA/358-05-01	Revision F
BHA/DRA/358-01-01	MATERIALS LIST	ALL DIMENSIONS TO BE MET AFTER PLATING. REMOVE ALL BURRS. BREAK ALL SHARP EDGES 0.015" (0.31mm) 0.1mm (0.004")	SURFACE ROUGHNESS U.N.O INCLUDING REAMED HOLES FOR UTILISED HOLES	MATERIAL																
BHA/DRA/358-01-02	MATERIALS LIST (CONTINUED)		BEND RADIIUS																	
			CORNERS AND FILLETS																	
		TOLERANCE: (Except where otherwise stated) Over Up to Tolerance 0 0.100 0.020 0.1 0.20 0.040 0.2 0.5 0.060 0.5 & OVER 0.080 ANGULAR TOLERANCE (U.N.O) +/- 0.5°	MARK PART # IN REGION MARKED: WELDING ALL WELDING FULL PENETRATION A 3mm DEEP MUST REMAIN ON AT LEAST ONE SIDE U.N.O	TREATMENT: REJECT SHIT ALL SPW PARAGRAPH 4.5 > 4.15 FOR SURFACE PREPARATION & PAINTING																